

Work Order ID 85097

85097

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June-01-12 3:43:31 PM

Item ID: D2672

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bearpaw 13" X 24", 206

Stop ***NS2***

Start Date: 01/06/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 15/06/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/04

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2672	Rev B1								
120	FLOW WATER JET	0.00							
120									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut Blank as per File D2672_BLANK								
<u>Waterjet 1" B1x</u>									
130	HAAS CNC VERTICAL MACHINING #1	0.00							
130									
HAAS I	Memo	0.00							
HAAS CNC vertical machine #1	1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA791 and Dwg D2672. Identify as D2672 3-Deburr								
			PO	12/07/05		9	0		12-07-04 (x9)
140	QC2- Inspect parts off machine FAI/FAIB	0.00							
140									
QC	Memo	0.00							
Quality Control			PO	12/07/05		9	0		12-07-04 (x9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 15/06/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC8- Inspect parts - second check

0.00

150

QC

Memo

0.00

Quality Control

OK 12/07/09

9

0

180

Identify as per dwg & Stock Location: _____

0.00

180

Packaging

Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

OK 12/7/10

ME 12-07-10

Dart Aerospace Ltd

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 85097

85097

Parent Item: D2672

D2672

Parent Item Name: Bearpaw 13" X 24", 206

Start Date: 01/06/2012

Required Date: 15/06/2012

Start Qty: 8.00

Required Qty: 8.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	253.2100	3.6	28.8			

MUHMWB10

UHMW 1" Black

**

Jim 12-6-24

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT018	230.1	
120972	3	
121346	27.1	
121851	200	
MAT019	1.5	
118814	1.5	
ST052	21.60999474	
121277	12.8	
121278	8.80999474	

121954

121954

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NOTE: Date & initial all entries

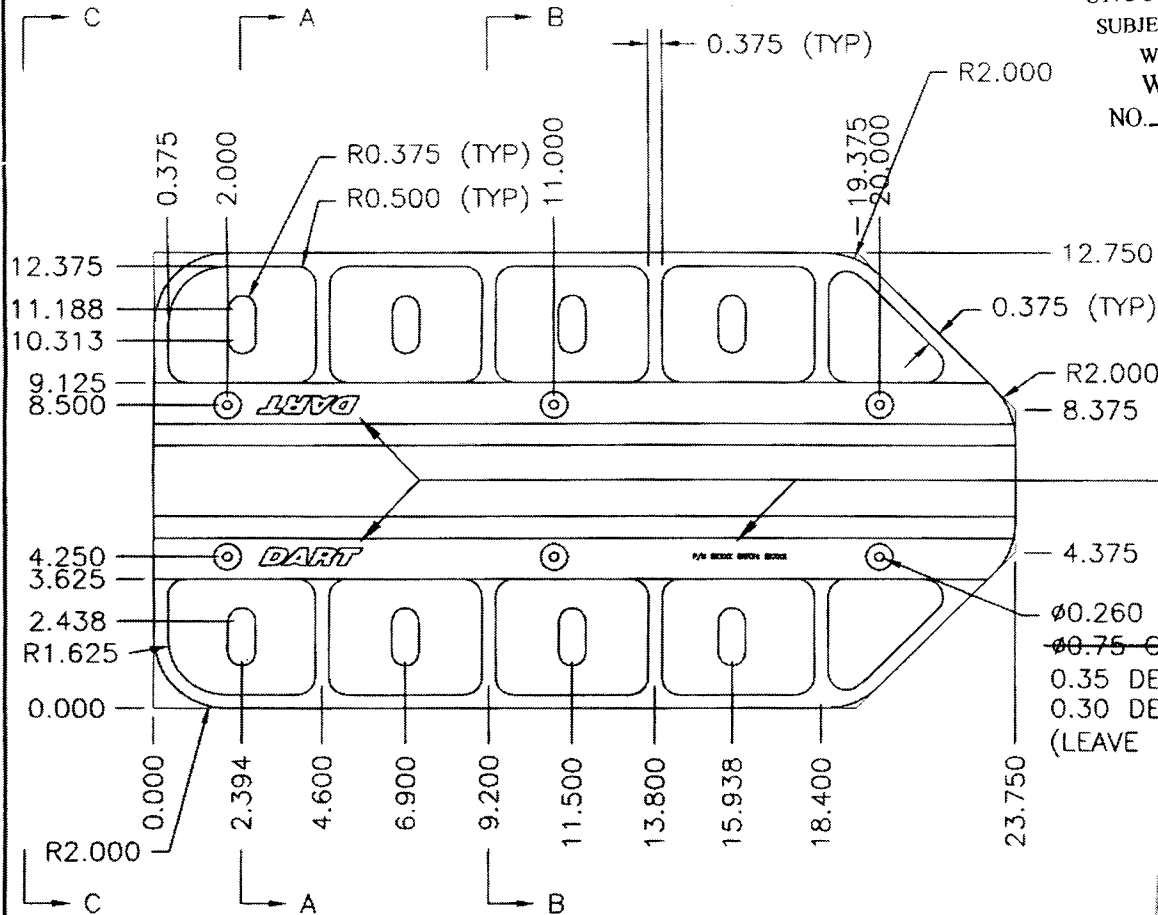
SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85097 MLJ 12/06/04

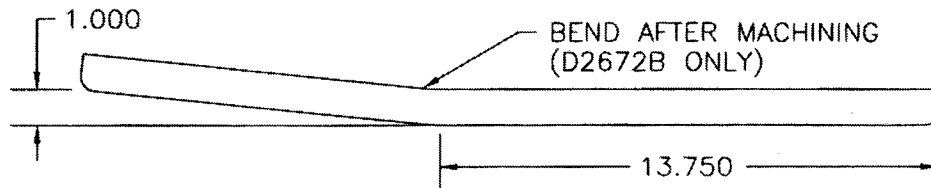
ENGRAVE LOGO TO
MAX DEPTH OF
0.012. ENGRAVE
PART AND BATCH
NUMBERS TO MAX
DEPTH OF 0.010.
(TYPICAL LOCATION
AS ILLUSTRATED)



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FLAT PATTERN



D2672F: FLAT BEARPAW
D2672B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	KE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	KE	D2672
DATE	TITLE	SCALE
98.05.19	BEARPAW	1:5
REV.	REV.	REV.
A	97.04.08	NEW ISSUE
B	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50
B1	02.10.22	0.43 WAS 0.75

EFFECTIVE	DEOS
9/43	

RELEASED
93.06.17 KE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

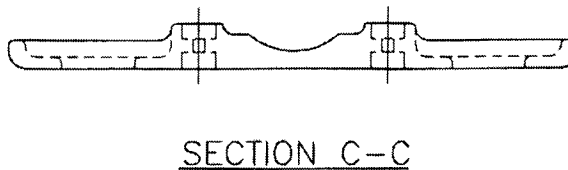
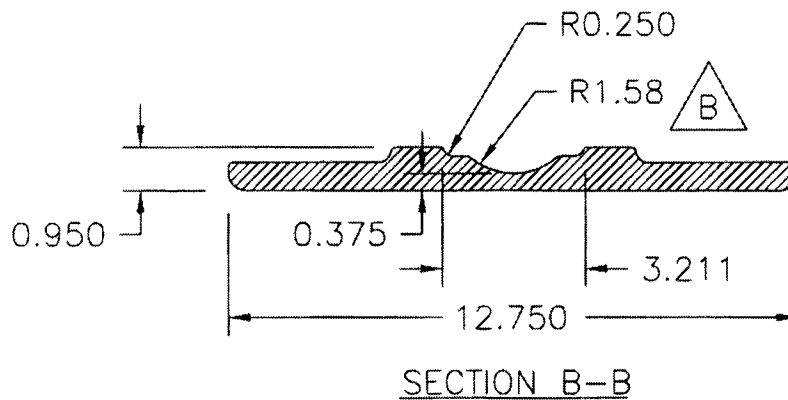
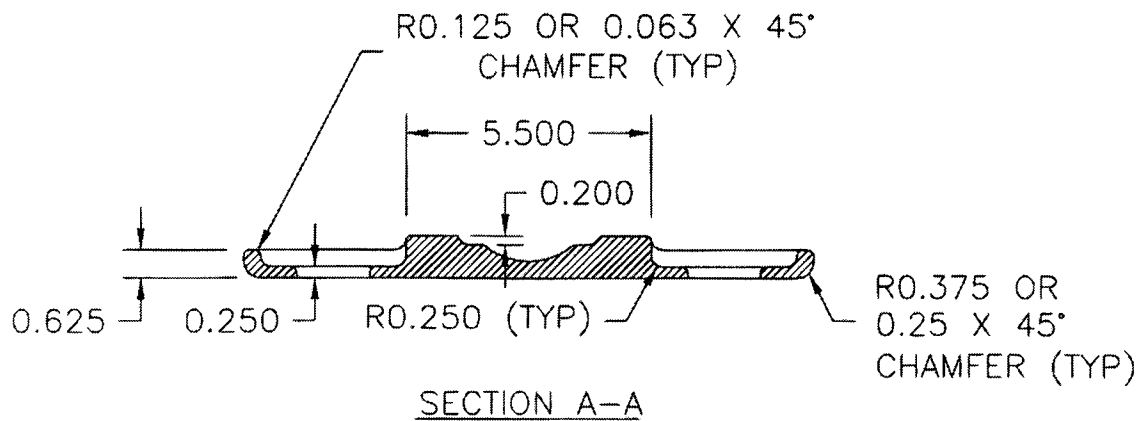
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BM</i>	APPROVED <i>SA</i>	DRAWING NO. D2672	REV. B SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
98.05.17 KE



tb038

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order: 88097
Description: Bearpaw		Part Number: D2672
Inspection Dwg: D2672	Rev: B1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	23.750	+/-0.030	23.750	✓		Tape	BT-11
B	12.750	+/-0.030	12.750	✓		"	
C	4.250	+/-0.010	4.255	✓		vern	BT-4
D	2.000	+/-0.030	1.993	✓		"	
E	9.000	+/-0.010	9.000	✓		Tape	BT-11
F	0.375	+/-0.030	.379	✓		vern	BT-4
G	9.000	+/-0.010	9.000	✓		Tape	BT-11
H	Ø0.260	+0.005/-0.000	.260	✓		vern	BT-4
I	Ø0.93	+/-0.030	.940	✓		"	
J	0.300	+0.030/-0.000	.301	✓		"	
K	0.625	+/-0.030	.621	✓		"	
L	0.063 x 45°	+0.030/-0.010	.056	✓		"	
M	0.250	+/-0.010	.252	✓		mic	BT-1
N	5.500	+/-0.030	5.504	✓		vern	BT-4
O	R0.250	+/-0.030	.250	✓		rad gauge	
P	0.200	+/-0.030	.191	✓		depth gauge	BT-6
Q	0.25 x 45°	+/-0.030	.249	✓		vern	BT-4
R	0.950	+0.030/-0.010	.956	✓		"	
S	0.375	+/-0.010	.378	✓		"	

Measured by: [Signature]	Audited by: [Signature]	Prototype Approval: N/A
Date: 12-07-04	Date: 12/07/04	Date:

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF [Signature]	[Signature]